QC:

Operation

Description

DOOSAN LATHE

**Revision Nbr** 

Rev A



Page 1

									• "5
1188111	Accept				<b>.</b> .	Setup (	Start Stop		
	12   13   14   15   15   15   15   15   15   15	Cust Item   Customer:	<b>(D:</b>						
Date:			ate:		F		Start Stop		
n on	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
				1414					
_ATHE Memo Turn as per Folio FA589 Rev: ∠	0.00 0.00 W & Dwg D3457 Rev:	2 11.	C - 22	)	40		<u>/</u>	, 'L-# '-	
ct parts off machine FAI/FAIB  Memo	0.00	2 11.	6. 2	22	40	0	<u>/</u>		
ct parts - second check	0.00	1116/2	3		40)				

120

110

QC

Quality Control

Sequence ID/

**Draw Nbr** 

D3457

Doosan

Doosan Lathe

**Work Center ID** 

Quality Control

QC8- Inspect parts - second check

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

## Work Order ID 70774

Wednesday, June 15, 2011 9:09:30 AM



Page 2

Item ID:

D3457-1

Accept

Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Washer

6/15/2011

QC:

**Start Qty: 40.00** 

Req'd Qty: 40.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date:

Date:

**Tooling:** 

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Run

Start

Stop

Stop



Required Date: 6/22/2011

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

0.00

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject Qty \_

Reject Insp. Number

Stamp

140

0.00



Quality Control

QC21- Final Inspection - Work Order Release

0.00

MF 11-06-23

## **Picklist Print**

Wednesday, June 15, 2011 9:09:37 AM

Work Order ID: 70774

D3457-1

Parent Item Name: Washer



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

Parent Item:

IPP A□05.10.03□New issue□KJ/JLM□

IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	6.8000	0.0208	0.875789			
										2=	((`•	د . 2	2_

Delrin Round Bar 1"

<u>Location</u>		Loc Qty	Loc Code
MAT055	_	6.8	
117985		6.8	

DART AEROSPACE LTD	Work Order:	70774
Description: Washer	Part Number:	D3457-1
Inspection Dwg: D3457 Rev: A		Page 1 of 1

		X First Artic	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
R1.575	+/-0.010	1.575			Da 02	_	
0.030 x 0.030	+/-0.010	03×.03					
0.530	+/-0.010	528		-			
0.063	+/-0.010	.005					
0.169	+/-0.010	.165				1	
Ø0.655	+/-0.010	- 655		_			· NL
Ø1.000	+/-0.010	1.002					
				,			
				-			
	7, T. S. V.						
20-21					<u>.</u>		
				· · · · · · · · · · · · · · · · · · ·			
leasured by: 🙃		Audited by:	40		Prototype	Approval:	N/A
Date: 11	1.6.22	Date:	4/6/	123		Date:	N/A

	 100/10		
		<del></del>	

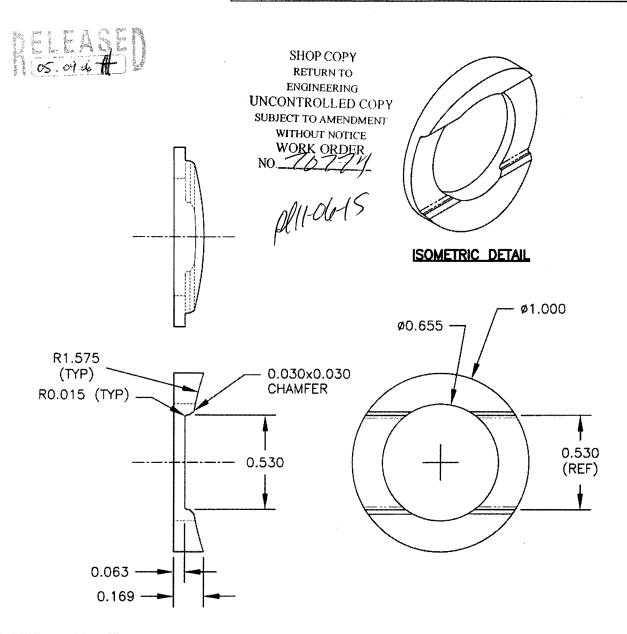
**Dart Aerospace Ltd** 

W/O:			WC	RK ORDER CHANGI	ES			·	
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	· 
Resolution:		esolution:	Disposition: QA			Closed:	Date:		
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	R)			· · · · · · · · · · · · · · · · · · ·
DATE	STEP	Description of NC	Corrective Action Section B			Verifi	cation	on Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ion °C	Chief Eng	QC Inspector
					1				

NOTE: Date & initial all entries



DESIG	N CP	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHEC	KED #	APPROVED	DRAWING NO.		REV. A
DATE		1 4	TITLE		SCALE
05.0	9.06		WASHER		2:1
Α		05.09.06	NEW ISSU	JE	



## **D3457-1 WASHER**

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Dart	Aer	osp	ace	Ltd
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	Johann								
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Da	ate Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•					
· · · · · ·		, , , , , , , , , , , , , , , , , , ,							
Part No	·	PAR #:	Fault Cate	jory:	_ NCR: Ye	s No	DQA:	Date: _	
Resolution:			Disposition	_ QA: N/C	QA: N/C Closed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (N	CR)			
DATE	STEP	Description of NC	Description of NC Corrective Act		V			Approval	Approval
	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n & ' ite	Section C	Chief Eng	QC Inspector
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\*NOTE: Date & initial all entries